



Dart Aerospace Ltd.
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D2739**Job Sheet 212302****Part No:** D2739**Job Qty:** 4 pcs**Part Name:** 350 I-Beam**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 8/19/20**Job Tracking No:****Due Date:** 9/11/20**Created By:** Marie Lajeunesse**Type:** Stock**Description:**

Note: DWG D2739 REV E IPP Rev: C 02.11.28 Reformat KJ IPP Rev: D 06-03-21 As Per Rev C JLM IPP Rev: E 07-07-28 As per Rev D JLM Verified By: IPP Rev: F 10.11.02 as per revE DD verf: EC

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Skidtubes - 1	4 pcs	9/10/20		0.00	4.64	Skidtubes - 1		
							Skidtubes - 2		
							Skidtubes - 3		MLL 20-08-20
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
110	QC 5	4 pcs	9/10/20		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		SE 08/20/20
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
120	Handfinish - 1 - 1 Chemical-B4B	4 pcs	9/11/20		0.00	0.80	Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 - B4B		

**Container No:** S295323**Part:** D2739**Job No:** 212302**Serial No/Batch:** S295323**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's

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Date: 08/20/20

Plex 8/19/20 1:45 PM Dart.lajeunesse.marie

					Handfinish - 1 - 4 - B4B	TF Aug. 24, 2020
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
					QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	DAS
					QC 7 - 3	03 20.8.27
					QC 7 - 30	9-89
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
130	QC 7	4 pcs	9/11/20	0.00 0.00		

140 Packaging 3-1 - Stock - B4B	4 pcs	9/11/20	0.00 0.00	QC 7 - 81	
				QC 7 - 76	
				QC 7 - 79	
				QC 7 - 83	
				QC 7 - 82	
				QC 7 - 87	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	DAS
				Packaging 3 - 26 - B4B	03 20.8.27
				Packaging 3 - 27 - B4B	9-89
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	DAS
150 QC 21 - SA	4 pcs	9/11/20	0.00 0.00	QC 21 - SA - 21	21 AUG 27 2020
				QC 21 - SA - 70	9-89 AUG 27 2020
				QC 21 - SA - 9	
				QC 21 - SA - 77	AUG 27 2020

Part Op 100 - (Skidtubes) 1-Cut D2600-5 to length as per Dwg D2739. 2-Drill pilot holes in web using drilling Jig DT8162 as per Descriptions: Dwg D2739 3-Use uni-bit to open holes to finish size as per Dwg D2739. 4-Bevel Fwd end of extrusion and Deburr holes and ends.

110 - QC5- Inspect part completeness to step on W/O

120 - (Chemical Conversion Coat per QSI005 4.1)

130 - (QC7- Inspect Chemical Conversion Coat)

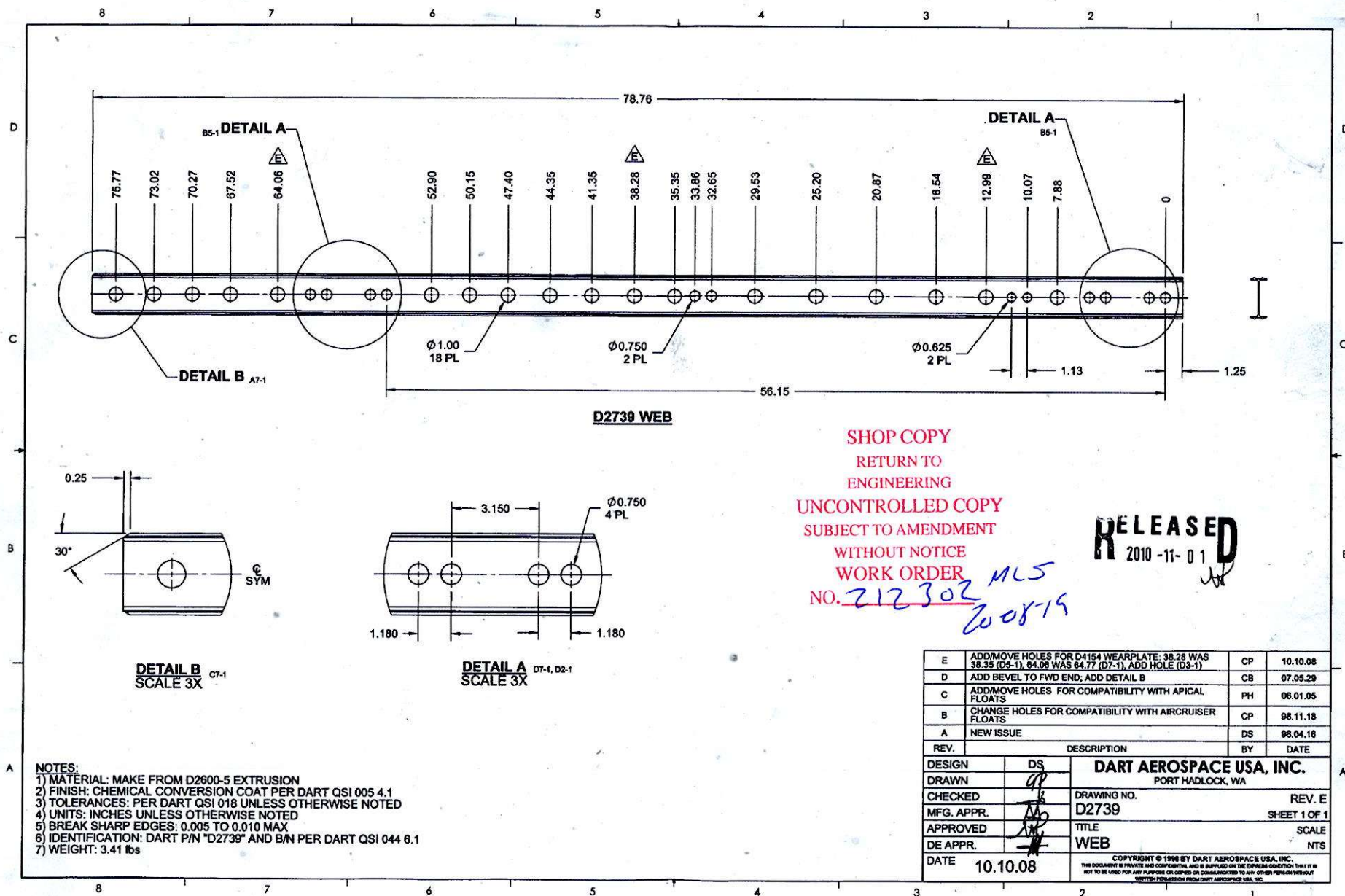
140 - (Identify as per dwg & Stock Location: _____) LOCATION : LG002

150 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2600-5-108	Extrusion I-Beam Thin	4 pcs (1 ea)	100-Skidtubes - 1	5146203

Job Allocations				
Operation 100-Skidtubes - 1	Component Part D2600-5-108	Required 4	Inventory 34	Allocated 0
Part Specifications				
Spec No	Description	Target/Tolerance	Limits	Type Special Comments
1	Web	78.760Inches $\pm$ 0.030	78.790 78.730	
2	Web	1.180Inches $\pm$ 0.010	1.190 1.170	
3	Web	3.150Inches $\pm$ 0.010	3.160 3.140	
4	Web	1.180Inches $\pm$ 0.010	1.190 1.170	
5	Web	0.250Inches $\pm$ 0.030	0.280 0.220	
6	Web	30.000Degrees + 0.500 - 5.000	30.500 25.000	Angle
7	Web	1.250Inches $\pm$ 0.030	1.280 1.220	
8	Web	7.880Inches $\pm$ 0.030	7.910 7.850	
9	Web	10.070Inches $\pm$ 0.030	10.100 10.040	
10	Web	12.990Inches $\pm$ 0.030	13.020 12.960	
11	Web	16.540Inches $\pm$ 0.030	16.570 16.510	
12	Web	20.870Inches $\pm$ 0.030	20.900 20.840	
13	Web	25.200Inches $\pm$ 0.030	25.230 25.170	
14	Web	29.530Inches $\pm$ 0.030	29.560 29.500	
15	Web	32.650Inches $\pm$ 0.030	32.680 32.620	
16	Web	33.860Inches $\pm$ 0.030	33.890 33.830	
17	Web	35.350Inches $\pm$ 0.030	35.380 35.320	
18	Web	38.280Inches $\pm$ 0.030	38.310 38.250	
19	Web	41.350Inches $\pm$ 0.030	41.380 41.320	
20	Web	44.350Inches $\pm$ 0.030	44.380 44.320	
21	Web	47.400Inches $\pm$ 0.030	47.430 47.370	
22	Web	50.150Inches $\pm$ 0.030	50.180 50.120	
23	Web	52.900Inches $\pm$ 0.030	52.930 52.870	
24	Web	64.060Inches $\pm$ 0.030	64.090 64.030	
25	Web	70.270Inches $\pm$ 0.030	70.300 70.240	
26	Web	73.020Inches $\pm$ 0.030	73.050 72.990	
27	Web	75.770Inches $\pm$ 0.030	75.800 75.740	
28	Web	56.150Inches $\pm$ 0.030	56.180 56.120	



Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor		
			QC / QA Coordinator		
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					